

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023923**Date Inspected:** 24-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspector: Sun Tian Liang

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Trial Assembly

ZPMC presented QA personnel with "Notification of Witness Inspection" document number 9248 that stated ZPMC was requesting Caltrans to perform visual and magnetic particle (MT) inspections of various OBG segment 13AW welds at the trial assembly area. This QA Inspector performed random visual and magnetic particle (MT) inspections of the following welds.

Item #1: SEG3013P-255, 248, 242, 237, 227, 253, 254, 246, 247, 240, 241, 235, 236, 230, 231, 225, 226

Item #3: SEG3013P-086

Item #6: SEG3013P-275, 277, 279, 280, 289, 287, 288, 285, 286

Item #8: SEG3013P-055, 058, 062, 065, 068, 066, 063, 059, 056

Item #10: DP3125-001-007, 010, 011, 008, 009, 035, 033, 037 and SEG3013P-013

Items observed by this QA Inspector appeared to comply with AWS D1.5 MT requirements. For additional

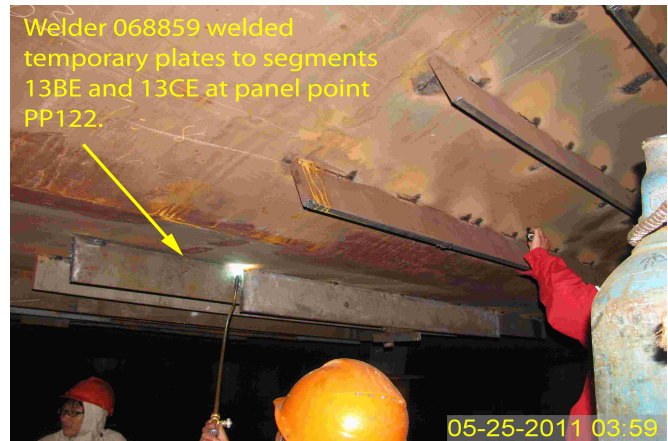
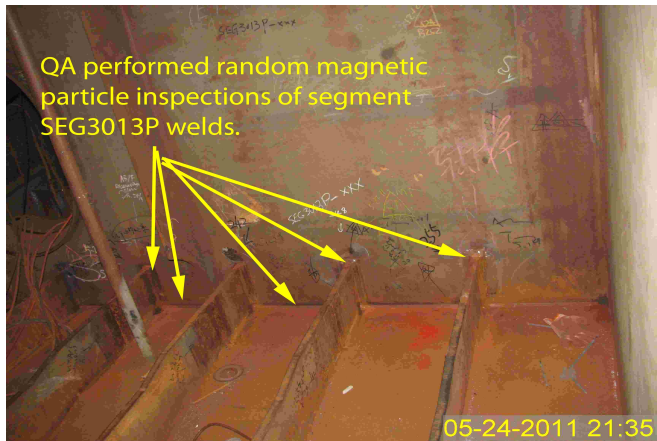
WELDING INSPECTION REPORT

(Continued Page 2 of 2)

information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report. See the photograph below for additional information.

This QA Inspector observed ZPMC welder Mr. Wang Changfa, stencil 058102 had used shielded metal arc welding procedure specification WPS-B-P-2112-FCM-1 and WPS-B-P-2114-FCM-1 to make segment 13CE welds LD3030-001-287, 288, 315, 316, 343 and 344. This QA Inspector observed Mr. Wang Changfa appeared to be certified to make these weld. This QA Inspector observed a welding current of approximately 180 amps, the base materials were heated with an electric heater. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yang Xing Long, stencil 068859 used shielded metal arc welding process to weld temporary plates on the cross beam side of the bottom plate near segments 13BE and 13CE, panel point PP122. This QA Inspector observed a welding current of approximately 165 amps, the base material had been preheated with a torch. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer
